

Date: Tuesday, 10/06/2008 10:24:11 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	R44 CARGO MIRROR
Job Number :	39748		
Estimate Number :	10095		
P.O. Number :		Part Number :	D044715011
This Issue :	10/06/2008	Drawing Number :	D3243
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	A
Previous Run :	38776	Material :	Manufacture in multiples of 10
Written By :		Due Date :	17/06/2008
Checked & Approved By :	JUD 08.06.10	Qty:	10 Um: Each
Comment :	Est Rev:A 04.02.18 New issue KJ/JLM Est Rev:B 06-04-28 Manufactured on Water Jet JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUD 08.06.11

10/06/11



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-715-011

CHG002
CHG001

10/06/11

2.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.5359 sf(s)/Unit Total : 4.2874 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063)
 Identify for D3243-1
 Batch: _____

3.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3243
 Dwg Rev: _____
 Prog Rev: _____

D3243-041

B

2-Deburr if necessary

* see Bottom of the 4th page *

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 39748

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3243

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

FE032EF

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 FE-032EF Insert

1 D3243-1(Ref) Bracket

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg d3243

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 10:24:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 39748

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0

D1048

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20 46.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D1048 Clamp M35037

17.0

D1049

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20 76.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D1049 Saddle 38274

18.0

D2010104

Mirror Arm 369/500



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2010-104 Arm B39681

19.0

D2011101

6" Mirror



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2011-101 Mirror 39555

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Tuesday, 10/06/2008 10:24:12 AM
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Job Number: 39748

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

ALS41032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~32.0000~~ 40 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 ALS4-1032-130 Insert

M105819

AS 08/06/11 (X10)

21.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~32.0000~~ 40 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN3-4A

Bolt

M103041

AS 08/06/11 (X10)

22.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~32.0000~~ 40 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN526C1032R10 Screw

M10867 x 38 M15072 x 2

AS 08/06/11 (X10)

23.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~32.0000~~ 40 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10L

Washer

M104885

AS 08/06/11 (X10)

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/06/11 (X10)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-715-011

Location:

Ken B

8/6/11

SL

D3243-041

B 38776 x 1
B 21266 x 9

AS 08/06/11 (X10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

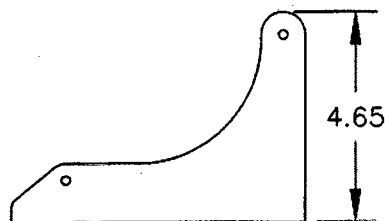
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09		TITLE BRACKET	SCALE 1:2
A	04.01.09	NEW ISSUE	



D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

RELEASED
04.02.03

INSTALL
FE-032-EF INSERTS
(4 PLACES)

2.75 $+0.030$
0.000

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39748

8.581
8.206
7.706

11.920
11.420

Ø0.201
(TYP 4
PLACES)

Ø0.290
(TYP 4
PLACES)

GRAIN
DIRECTION

1.375

5.273

4.214
R0.25 (TYP)

3.714

3.339

R0.38
(TYP)

5.494

R2.75
(TYP)

D3243-1
FLAT PATTERN

R0.50
(TYP)

0.500

0.000

0.750
0.500
0.000

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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